

Work Order ID 73156

Friday, August 26, 2011 7:10:05 AM



Page 1

Item ID: D350-591-133

Accept



Setup Start



Revision ID:

Item Name: Aft Maintenance Step

Stop



Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *11-08-08* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2946	Rev B								

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-133 CHG003

Sw/10/25

JD GRMLT 11-10-20

(4)

110



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

11-10-10

4

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC3- Inspect part completeness to step on W/O

0.00

QCB

Memo

0.00

C/L 11.10.04

44

PTO

130



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Deburr and Bevel ends for welding

12.11.10.13

4

0

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/RAluminum Rod

114514

118735

3-Grind End Cap welds flush

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

4

0

BE 11/10/14

W/O: 73156		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-10-04	120	Change to QC 6		11-10-27			

Part No: D350-591-133 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5 in 10/11/17

Quality Control

(24)

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4Xφ M-φ 11/10/17

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 φ 11/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Large Fab	Large Fab	0.00							
	Memo	0.00							
	Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. A/R AL ROD BATCH: 115414			211.10.18		4	0		
190 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
	Quality Control								
200 QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

W/O:		WORK ORDER CHANGES					
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Page 5

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00				4	BR	11-10-19	
	Hand Finishing								
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
	Powder Coating								
	Memo								
	START TIME: 11:15								
	OVEN TEMPERATURE: 3200 F								
	FINISH TIME: 11:45								
230	Wing Walk as per dwg QSI005 4.4 Batch 118988	0.00							
	HandFinish	0.00				4	BR	11-10-19	
	Hand Finishing								

4X Ø M/L 11/10/19

4. BR 11-10-19

M117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 6

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Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 covered f 11/10/24

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SP 11-10-24

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/25

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

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Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per PPPD350-591-133								
	Location: _____								
	PPP Rev: <u>D</u>								
280	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								
	Memo	0.00							

SP 11-10-26

mlw/27

MF 11-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:10:00 AM

Page 1

Work Order ID: 73156

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B05.10.14 Modified step 10 KJ/EC
IPP Rev:B06.07.19 D2946 @ rev.b EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

110

Each

191.7000

0.52

2.08



Step Extrusion

Location

Loc Qty

Loc Code

HALL

182

64409

6

68293

59

72131

117

WA

9.7

46910

2

66970

7.7

D2734

Manufactured No

130

Each

29.0000

2

8



Step End Plate

Location

Loc Qty

Loc Code

WA

BT3196

29

70701

29

D2944

Manufactured No

130

Each

6.0000

2

8



Step Mounting Plate

Location

Loc Qty

Loc Code

WA018

BT3427

6

66177

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, August 26, 2011 7:10:00 AM

Page 2

Work Order ID: 73156

Parent item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Sx AN4-11A
Bolt

Purchased No

250 Each

194.0000

4 16



SP 11-10-24

Location

Loc Qty

Loc Code

ST356

100

117872

100

ST357

94

110382

1

115316

93

Sx AN4-14A
Bolt

Purchased No

250 Each

196.0000

8 32



10x
SP 11-10-24

Location

Loc Qty

Loc Code

ST357

96

118451

96

ST358

100

118628

100

Sx AN4-16A
Bolt

Purchased No

250 Each

106.0000

8 32



SP 11-10-24

Location

Loc Qty

Loc Code

ST358

106

117514

6

117872

100

Sx AN4-7A
Bolt

Purchased No

250 Each

202.0000

2 8



32x
SP 11-10-24

Location

Loc Qty

Loc Code

ST356

202

117443

2

117514

200

8x

Friday, August 26, 2011 7:10:01 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, August 26, 2011 7:10:01 AM

Page 3

Work Order ID: 73156

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased No

250 Each

0.0000

14 56

m 118612



Sp 11-10-24.

Washer D2230-1 Manufactured No

250 Each

225.0000

4 16



Sp 11-10-24.

Lug

Location	Loc Qty	Loc Code
ST476	225	
67826	6	
69179	19	
69821	100	
70974	100	

Manufactured No

250 Each

216.0000

4 16



B73396 16x

Sp 11-10-24.

Location	Loc Qty	Loc Code
ST	200	
71964	100	
72125	100	
ST476	4	
53881	4	
ST480	12	
70973	12	

Manufactured No

250 f

582.3981

2



Sp 11-10-24

D2732 Rubber Extrusion

Location	Loc Qty	Loc Code
ST410	582.39811	
64283	83.52811	
70987	498.87	

-5 x

B73359 -3 x

Friday, August 26, 2011 7:10:01 AM

Shop Packet Print

Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Work Order ID: 73156

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2856-400

Manufactured No

250

f

225.7845

1.26

5.04



Abraison Strip



Sp 11-10-21

Location

Loc Qty

Loc Code

ST403

14.1149

68076

14.1149

ST409

211.6696

63735

0.6696

71164

211

5.04

(2X) 4.00" X 7.20" per dwg

D2945

Manufactured No

250

Each

12.0000



Step Mounting Plate



Sp

Location

Loc Qty

Loc Code

ST027

12

70880

12

Purchased No

250

Each

4,143.000

MS21042L4



Nut



4x

56

Sp 11-10-21

Location

Loc Qty

Loc Code

ST300

4143

117441

57

117601

637

117885

1449

118451

2000

56x

Friday, August 26, 2011 7:10:02 AM

Shop Packet Print

Page 4

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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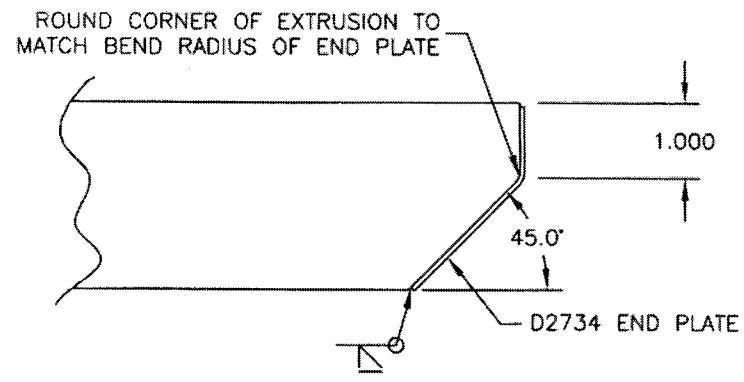


D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

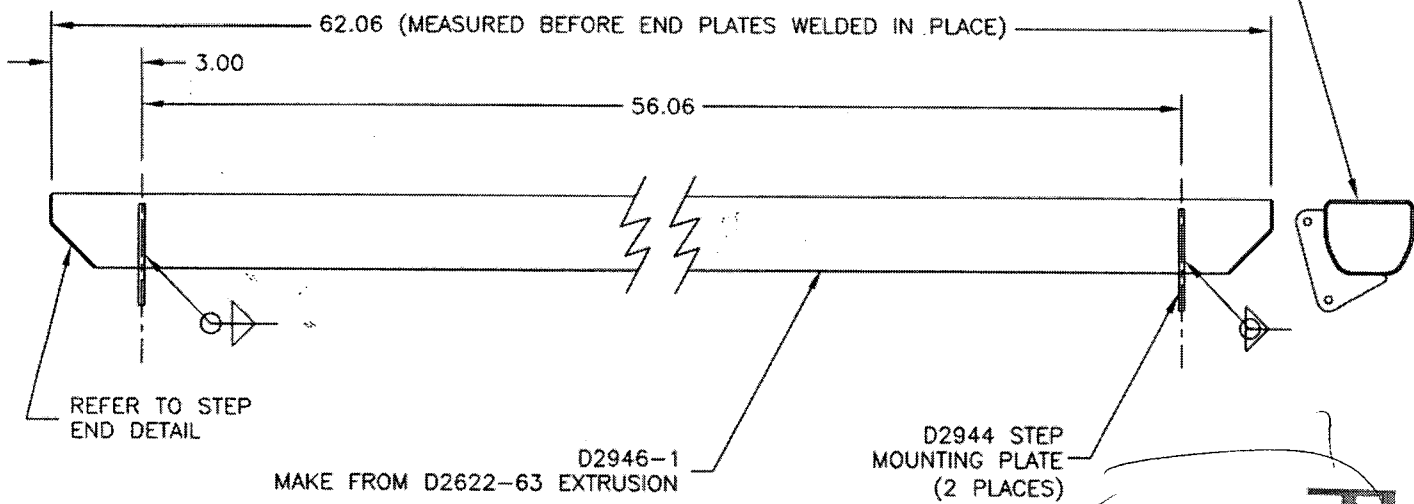
*cut per drawing

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DATE	CHECKED	APPROVED	DRAWING NO.	TITLE	REV. B
CP	PH	05.11.14			D2946	STEP ASSEMBLY	SHEET 1 OF 1
A		99.12.13			NEW ISSUE		SCALE 1:6
B		05.11.14			UPDATE FINISHING NOTE		

RELEASED
05.11.28

#73154

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5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

REFERENCE ONLY

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	Heli-Access-Step™, Short Step – High Skid, LH
	X				D350-591-122	Heli-Access-Step™, Short Step – High Skid, RH
		X			D350-591-123	Heli-Access-Step™, Short Step – Low Skid, LH
			X		D350-591-124	Heli-Access-Step™, Short Step – Low Skid, RH
				X	D350-591-133	Heli-Access-Step™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT



The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	gp	DART AEROSPACE LTD	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	pt	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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